

Work Order ID 63372

Page 1

Thursday, October 28, 2010 10:15:41 AM

Item ID: D206-642-541

Accept



Setup Start



Revision ID:

Stop



Item Name: Replacement Skidtube

Start Date: 10/28/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 11/11/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

Date: 10-10-20 Tooling:

Date:

Run Start



QC:

Date: SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D3274

D

IIN-D206-642

Rev M

100

0.00



DOCUMENT CONTROL

DC

0.00

Memo

Document Control

Photocopy bluefile & type labels per PPP D206-642-541 CHG003

N/A

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

110

0.00



Skidtubes

Skidtubes

0.00

Skidtubes

Memo

****VERIFY AND INSPECT THE MATERIAL PRIOR TO USE****

1- Bend FWD end of tube using bend prog D3274 FWD and foil 10 as per dwg D3274, cut fwd end of tube with saw table setup D3274.

2- remove fwd indexing ridge as per dwg D3274. Prepare for welding

3- weld fwd cap as per dwg D3274 and QSI004

AR Aluminum Rod Batch:

4- grind fwd cap weld on top surface only

5- Cut AFT end of tube at 170.9" as per dwg D3274 and deburr end.

6-Drill Aft cap pilot hole using DT8025

7 -Cleco DT8025 in position and install pilot hole drill Jig DT8742A,B,C,D.
Drill 3/16" pilot holes as per Dwg D3274

8 -Remove inner indexing ridge on aft end of skidtube as per Dwg D3274 scribe batch #

9 -Open aft end cap holes to Ø0.208" as per Dwg D3274. Deburr aft end.

DP 10-10-3

MI11385/MI15778 BE 10-11-03
BE 10/11/03

BB 10/11/09

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Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00				1			BE 10/11/09
130 QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00				1	0		BE 10/11/10
140 QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00				0			

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Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150

0.00



Skidtubes

Skidtubes

Memo

0.00

1-Open Ø0.313" and 0.375" crossbolt spacer holes as per Dwg D3274

2-Deburr crossbolt spacer holes as per Dwg D3274 and blow out chips from inside the tube

3-Bond web in place as per Dwg D3274 & QSI 015.

A/R. ☐ Sikaflex-291 ☐ 116040 ☐Sikaflex expire date: ☐ 11-9-30 ☐Start: ☐ 10/11/16 ☐ Time: ☐ 4:00 ☐Finish: ☐ 10/11/16 ☐ Time: ☐ 7:40am

(Adhere for 12 hours)

10-11-16

BB 10/11/16

160

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

170

0.00



Skidtubes

Skidtubes

Memo

0.00

1-Bend AFT end of tube using bend prog. D3274 AFT as per dwg D3274. Install drop pins in crossbolt spacer holes to maintain web position.

2- DRILL PILOT HOLES FOR WEARPLATES USING D3274-1T2
OPEN HOLES TO .297" . Debur

3-DRILL TOE PIN HOLE .640" DIA AS PER DWG USING DT8935 FWD
END OF TUBE
DEBURR INSIDE OF HOLE AS NECESSARY (DO NOT ENLARGE HOLES)
REMOVE ANY FOREIGN OBJECTS INSIDE OF TUBES

4- Countersink crossbolt spacer holes as per Dwg D3274

5- prepare for welding

180

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

h=3.0"

L=4.2"

Scoldw/1/10

70

10/11/18

10-11-17

W/O:		WORK ORDER CHANGES					
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QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

190

0.00



Skidtubes

0.00

Skidtubes

Memo

1-Insert D2649 & D3275-1 crossbolt spacers. Weld as per QSI 004 and Dwg D3274. Remember to back drill each hole before welding the other side. Use aluminum rod
A/R ☐ Aluminum Rod ☒ *11/1/22*

3-Grind cross bolt welds flush as per Dwg D3274.

4-Counterbore 5/16" x 0.750" deep as per Dwg D3274 and deburr.

200

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

BE 10/11/22
3 BE 10/11/23

8.10.11.23



W/O:		WORK ORDER CHANGES					
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Reference:

Cust Item ID:

Customer:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

210



QC

Quality Control

QC10- Inspect visual per QSI004- ground welds

0.00

8/01/123

0.00

Memo

220



HandFinish

Hand Finishing

Pressure Wash per QSI005 4.3

0.00

7/10/11/23

0.00

Memo

Re-alodine tube as per QSI 005 section 4.1.2.1 do not acid etch

1/0

230



Powdercoat

Powder Coating

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

M115951

0.00

Memo

START TIME: 8:25
OVEN TEMPERATURE: 320°
FINISH TIME: 8:55

1/10-11-29

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
240  QC Quality Control	QC3- Inspect Part Finish Memo	0.00 => Jell 10/11/29 0.00				1	0		
250  HandFinish Hand Finishing	HandFinishing Memo 1-Install Nut Plate as per Dwg D3274. Apply LPS-3 to Nut Plate and rivets. A/R <input type="checkbox"/> N/A <input type="checkbox"/> LPS-3 <input type="checkbox"/> M109956 2-Install inserts as per Dwg D3274. Use a drop of Sikaflex inside insert holes a A/R <input type="checkbox"/> <input type="checkbox"/> Sikaflex-291 <input type="checkbox"/> M115114 <input type="checkbox"/> Sikaflex expire date: <input type="checkbox"/> 11/01	0.00 => Jell 10/11/29 0.00				1	0		Do =>
260  QC Quality Control	QC5- Inspect part completeness to step on W/O Memo Inspect Nut Plate & Inserts	0.00 Sukr/03 0.00							

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D200-642-541 PAR #: _____ Fault Category: Skull holes NCR: Yes No DQA: ✓ Date: 10/12/14
 Resolution: re-work Disposition: rework QA: N/C Closed Date: 10/12/14

NCR: <u>03372</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
10/11/14	250	Found at step 250 that the .098" holes in D3285-1 were not cut correctly cut on water jet. holes are oval/clogated	CP 10.11.30 QSI/UP	REPLACE CAP. TOUCH-UP / RE-FINISH AS REQ'D	DP BE 10/11/30	S 10/12/14	CP 10.11.30 QSI/UP	S 10/11/14
		was not seen on w/o 52647 and not caught before welding R.C. Material blowout because of the water jet process.	CP 10.11.30	A/R m111385 m15778 D3285-1 352647	BE 10/11/30	S 10/12/14	CP 10.11.30	S 10/11/14
			QSI/UP	→ Touch up Alodine per as2005 → Touch up re plc per as2005 START 11:00 FINISH 11:30	BE 10/12/14	S 10/12/14	QSI/UP	S 10/11/30

NOTE: Date & initial all entries

QSI/UP
FINISH 11:30
acc re plc 75/12/14

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QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

270



HandFinish

Hand Finishing

HAND FINISHING RESOURCE #1

0.00

0.00

Memo

✓ 1-Install wearpads & gaskets as per Dwg D3274.

2-Install ring as per Dwg D3274

✓ A/R ☐ Sikaflex-291 ☐ 11/15/14 ☐

Sikaflex expire date: ☐ 11/10/14

3-Inspect for foreign objects as per QSI 024

4-Spray inside of tube on both sides of web with LPS-3

✓ A/R LPS-3 Batch: 124

5-Install Aft Cap and seal with Sikaflex. Clean excess adhesive.

✓ A/R ☐ Sikaflex-291 ☐ 11/15/14 ☐

Sikaflex expire date: ☐ 11/10/14

280



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

10/11/14 11/10/14

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Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
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DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

290

Identify as per dwg & Stock Location:

0.00



Packaging

Memo

PP 62258

0.00

Packaging

300

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/12/14

10/12/14

ME

10-12-10

W/O:		WORK ORDER CHANGES					
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Picklist Print

Thursday, October 28, 2010 10:15:48 AM

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Work Order ID: 63372

Parent Item: D206-642-541

Parent Item Name: Replacement Skidtube




Start Date: 10/28/2010

Required Date: 11/11/2010

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:B 05.09.23 Revised per D206-642 Rev. J KJ/JLM
 IPP Rev:C 07-02-23 Added SS Wearplates & Gaskets JLM
 IPP Rev:D 07-12-06 replace NAS1515H3L to D3672-1 DD
 IPP Rev:E 08-04-17 as per PAR 08-015 DD verified by:EC
 IPP Rev:F 08-06-02 add comment DD verified by:EC
 IPP Rev:G 08-10-09 revise details DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2600-1-190  Extrusion Round 3" 206		Manufactured	No			110	Each	63.0000	1	1			
<div> <div>Location</div> <div>Loc Qty</div> <div>Loc Code</div> </div> <div> <div>LG</div> <div>63</div> <div>①</div> </div> <div> <div>47575</div> <div>15</div> <div></div> </div> <div> <div>59874</div> <div>48</div> <div></div> </div>													
D3285-1  Cap		Manufactured	No			110	Each	141.0000	1	1			
<div> <div>Location</div> <div>Loc Qty</div> <div>Loc Code</div> </div> <div> <div>LG</div> <div>141</div> <div></div> </div> <div> <div>52511</div> <div>74</div> <div></div> </div> <div> <div>52647</div> <div>67</div> <div></div> </div>													
D3282-041  Float Web (206L/407)		Manufactured	No			150	Each	0.0000	1	1			

B 63389

DP 10-10-3

★ (+) BE 10/11/30
 1 BE 10/11/03

1 BB 10/18/16

W/O:		WORK ORDER CHANGES					
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Required Date: 11/11/2010

Start Qty: 1.00

Required Qty: 1.00

D2649

Manufactured No

190 Each

107.0000 12 12



Cross Bolt Spacer

Location

Loc Qty

Loc Code

LG	107
58545	2
60652	4
61496	13
62889	88



B 63359 12 BE 10/11/22

D3275-1

Manufactured No

190 Each

216.0000 12 12



Crossbolt Spacer

Location

Loc Qty

Loc Code

LG	216
53453	8
61646	102
62399	106



12 BE 10/11/22
2
10/11/22

CR3212-4-03

Purchased No

250 Each

1,874.000 2



Cherry Rivet

Location

Loc Qty

Loc Code

ST311	1874
111359	5
112314	2
114436	448
114450	71
114859	1348



X2

Thursday, October 28, 2010 10:15:48 AM

Shop Packet Print

Page 2

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Required Date: 11/11/2010



Start Qty: 1.00

Required Qty: 1.00

D3415-041	Manufactured	No	250	Each	52.0000	1	1
							<u>10/11/29</u>
Nut Plate							



<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

ST056	52	
<u>33842</u>	52	

CCR264SS3-3	Purchased	No	250	Each	416.0000	2	2
							<u>10/11/29</u>
Cherry Rivet							

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

ST311	416	
112314	4	
113539	44	
<u>113973</u>	368	

ALS4-1032-130	Purchased	No	250	Each	2,653.000	78	78
							<u>10/11/29</u>
Insert							

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

PKG11	886	
114723	886	
ST282	1728	
110511	10	
115911	1718	
ST381	39	
114654	39	

1116049

178

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Shop Packet Print

Page 3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Thursday, October 28, 2010 10:15:48 AM

Page 4

Work Order ID: 63372

Parent Item: D206-642-541

Parent Item Name: Replacement Skidtube

Start Date: 10/28/2010

Required Date: 11/11/2010

Start Qty: 1.00

Required Qty: 1.00

D3536-15 Manufactured No

270

Each

18.0000

1



Gasket



1
10/12/07

Location

Loc Qty

Loc Code

FP

6

B63568

56055

1

60875

5

FP11

12

59238

1

62459

11

D3536-23 Manufactured No

270

Each

3.0000

1



Gasket

B63238



1
10/12/07

Location

Loc Qty

Loc Code

FP011

3

61237

3

D3536-35 Manufactured No

270

Each

16.0000

1



Gasket



1
10/12/07

Location

Loc Qty

Loc Code

FP012

16

B65579

58683

1

61692

3

62462

12

D3536-39 Manufactured No

270

Each

12.0000

1



Gasket



1
10/12/07

Location

Loc Qty

Loc Code

FP12

12

B63578

58215

1

58571

11

1
10/12/07

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Shop Packet Print

Page 4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Thursday, October 28, 2010 10:15:48 AM

Work Order ID: 63372



Parent Item: D206-642-541



Parent Item Name: Replacement Skidtube

Start Date: 10/28/2010

Required Date: 11/11/2010

Start Qty: 1.00

Required Qty: 1.00

D3535-15 Manufactured No

270 Each

22.0000 1 1



10/12/07

Wearshoe

LocationLoc QtyLoc Code

FP18

22

61241

6

62241

3

62707

13

D3535-35 Manufactured No

270 Each

26.0000 1 1



10/12/07

Wearshoe

LocationLoc QtyLoc Code

FP018

26

60865

6

62461

12

62969

8

D3535-39 Manufactured No

270 Each

27.0000 1 1



10/12/07

Wearshoe

LocationLoc QtyLoc Code

FP18

27

60233

16

62945

11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Thursday, October 28, 2010 10:15:48 AM

Page 6

Work Order ID: 63372



Parent Item: D206-642-541



Parent Item Name: Replacement Skidtube

Start Date: 10/28/2010

Required Date: 11/11/2010

Start Qty: 1.00

Required Qty: 1.00

D3535-23

Manufactured No

270

Each

28.0000

1

1



10/12/07

Wearshoe

Location

Loc Qty

Loc Code

FP

7

61830

6

FP021

21

60231

8

62706

13

X1

D3537-3

Manufactured No

270

Each

40.0000

1

1



10/12/07

Wearpad

Location

Loc Qty

Loc Code

FP17

40

60866

3

61674

17

62705

20

X1

D3537-1

Manufactured No

270

Each

66.0000

9

9



10/12/05

Wearpad

Location

Loc Qty

Loc Code

FP

1

55465

1

FP017

59

61986

15

62209

44

FP17

6

57713

3

60491

3

1363545

X9

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Shop Packet Print

Page 6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Thursday, October 28, 2010 10:15:48 AM

Page 7

Work Order ID: 63372

Parent Item: D206-642-541

Parent Item Name: Replacement Skidtube

Start Date: 10/28/2010

Required Date: 11/11/2010

Start Qty: 1.00

Required Qty: 1.00

AN960C10L NAS1149C0332 Purchased No

270 Each 29.0000 80 80



washer

1115832



x80 10/12/07

Location

Loc Qty

Loc Code

ST245

29

107534

29

AN960C416 NAS1149C0463 Purchased No

270 Each 30.0000 1 1



washer

1115358



x1 10/12/07

Location

Loc Qty

Loc Code

ST346

30

100993

30

D3672-1 Manufactured No

270 Each 847.0000 2 2



Phenolic Washer



10/12/07

Location

Loc Qty

Loc Code

ST077

847

42329

150

52505

697

x2

Thursday, October 28, 2010 10:15:48 AM

Shop Packet Print

Page 7

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Thursday, October 28, 2010 10:15:48 AM

Page 8

Work Order ID: 63372

Parent Item: D206-642-541

Parent Item Name: Replacement Skidtube

Start Date: 10/28/2010

Required Date: 11/11/2010

Start Qty: 1.00

Required Qty: 1.00

AN3C4A

Purchased

No

270

Each

2,233.000

80

80



BOLT



10/12/07

Location

Loc Qty

Loc Code

ST303

3

115438

3

ST350

2230

114108

14

114416

12

114523

2

115300

202

115589

1000

115936

1000

180

AN4C5A

Purchased

No

270

Each

481.0000

1

1



BOLT



10/12/07

Location

Loc Qty

Loc Code

ST346

481

110552

4

112243

477

1

D2646

Manufactured

No

270

Each

45.0000

1

1



Aft Cap



10/12/07

Location

Loc Qty

Loc Code

FP-4

35

57332

35

B63633

1

fp5

6

62652

6

FP6

4

52663

4

Thursday, October 28, 2010 10:15:48 AM

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Page 8

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Thursday, October 28, 2010 10:15:48 AM

Page 9

Work Order ID: 63372



Parent Item: D206-642-541



Parent Item Name: Replacement Skidtube

Start Date: 10/28/2010

Required Date: 11/11/2010

Start Qty: 1.00

Required Qty: 1.00

D3413-1

Manufactured No

270

Each

23.0000

1

1



del 10/12/07

Ring

Location

Loc Qty

Loc Code

ST473

23

51586

1

53446

7

61322

15

yl

Thursday, October 28, 2010 10:15:48 AM

Shop Packet Print

Page 9

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN CP	DRAWN BY PH	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3274	REV. D SHEET 1 OF 4
DATE 06.12.19		TITLE SKIDTUBE ASSEMBLY SCALE NTS	
A	04.03.15	NEW ISSUE	
B	04.08.09	MOVE SADDLE HOLE: 42.14 WAS 42.76	
C	05.03.16	ADD -043; NEW INSERTS	
D	06.12.19	NEW INSERTS, SS WEARSHOE + GASKET	

RELEASED
07.02.12 *[Signature]*
DEO ATTACHED

Qty -041	Qty -043	Part Number	Description
X		D3274-041	SKIDTUBE ASSEMBLY
	X	D3274-043	SKIDTUBE ASSEMBLY
1	1	D2600-1-240	EXTRUSION
1	1	D2646	AFT CAP
12	12	D2649	CROSS BOLT SPACER
12	37	D3275-1	CROSS BOLT SPACER
1	1	D3282-041	FLOAT WEB
1	1	D3285-1	CAP
1	1	D3413-1	RING
1	1	D3415-041	NUT PLATE
1	1	D3535-15	WEARSHOE
1	1	D3535-23	WEARSHOE
1	1	D3535-35	WEARSHOE
1	1	D3535-39	WEARSHOE
1	1	D3536-15	GASKET
1	1	D3536-23	GASKET
1	1	D3536-35	GASKET
1	1	D3536-39	GASKET
9	9	D3537-1	WEARPAD
1	1	D3537-3	WEARPAD
78	78	ALS7-1032-130	INSERT (or AKS4-1032-130, ALS4-1032-130, AELS-1032-130)
80	80	AN3C4A	BOLT
1	1	AN4C5A	BOLT
1	1	AN960C416	WASHER
80	80	AN960C10L	WASHER
2	2	CCR264SS3-3	RIVET
2	2	CR3212-4-03	RIVET
2	2	NAS1515H3L	WASHER

GENERAL NOTES:

- TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- DAMAGE TOLERANCE ON FWD BEND:
THERE SHOULD BE NO VISIBLE WRINKLES IN THE BEND FROM THE GROUND TO A HEIGHT OF 7 INCHES ABOVE THE GROUND. IT IS ACCEPTABLE TO POLISH OUT GOUGES UP TO 0.020 DEEP IN THE BENT PORTION OF THE TUBE. A MAXIMUM REDUCTION IN DIAMETER OF 0.150" IS ACCEPTABLE IN THE BENT PORTION OF THE TUBE.
- ALL HOLES DRILLED ON CENTERLINES.
- BOND D3282-041 FLOAT WEB INTO D3274-1/-3 OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241/291 ADHESIVE PER DART QSI 015. ENSURE HOLES LINE-UP.
- WELDING TO BE DONE PER DART QSI 004.
- FINISH: - ACID ETCH, ALODINE ASSEMBLY PER DART QSI 005 4.1
- POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3
- DRILL Ø0.297 HOLES FOR ALS7-1032-130 INSERTS USING DT3274-1T2 BEFORE FINISH. INSTALL ALS7-1032-130 INSERTS AFTER FINISH. SEAL WEARSHOE BOLTS WITH SIKAFLEX -241/-291.
- SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND INSTALLATION OF INSERTS. COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF POWDER COATING WITH MEK DEGREASER.

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SHOW
RETURN
ENGINE
IN CONTR
SUBJECT TO
WITHOUT
WORK

NO. *43372*

PS 10-10-21

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

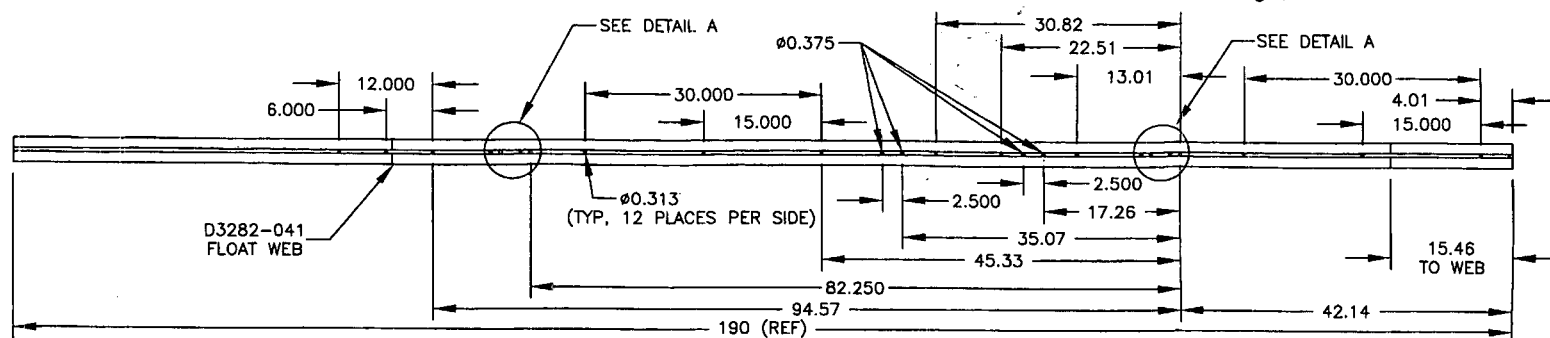
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NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

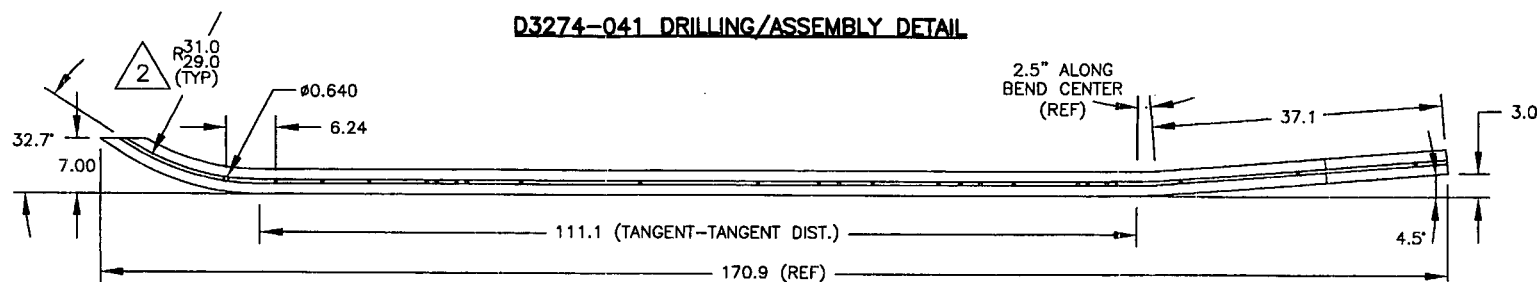
NOTE: Date & initial all entries

DEO ATTACHED

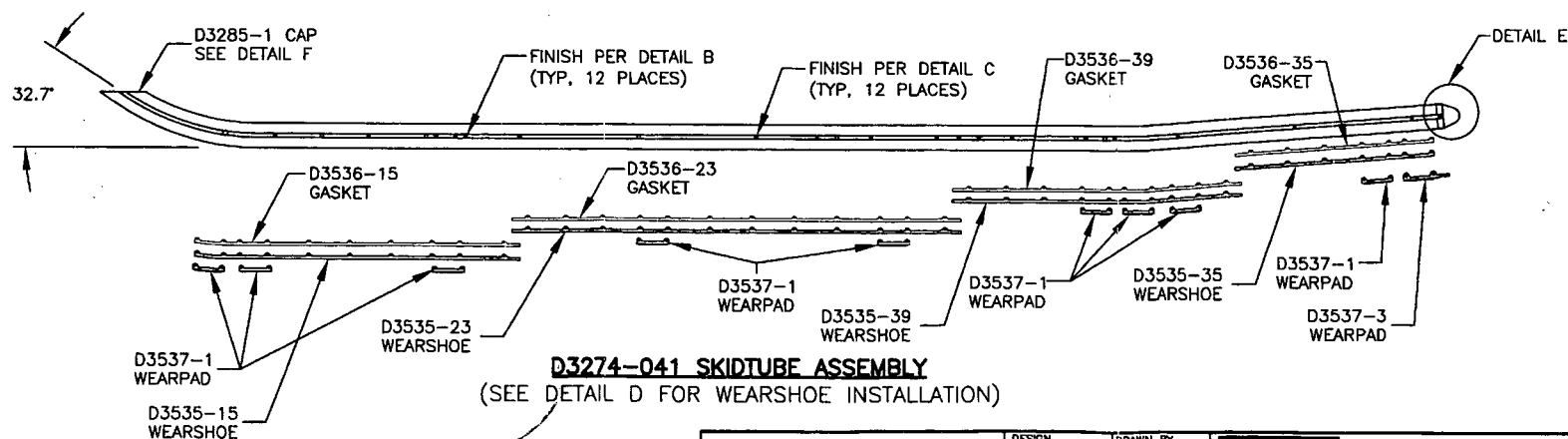
ULO 43372



D3274-041 DRILLING/ASSEMBLY DETAIL



D3274-041 BEND/DRILLING DETAIL



D3274-041 SKIDTUBE ASSEMBLY
(SEE DETAIL D FOR WEARSHOE INSTALLATION)

RELEASED

07.02.12

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DESIGN CP	DRAWN BY PH	DART DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED #	APPROVED #	DRAWING NO. D3274	REV. D SHEET 2 OF 4
DATE 06.12.19	TITLE SKIDTUBE ASSEMBLY		SCALE 1:15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

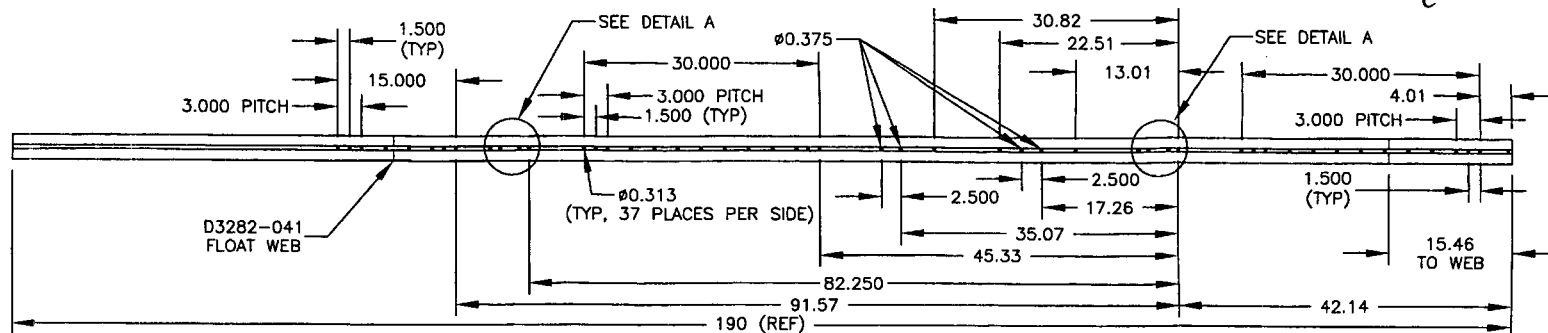
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

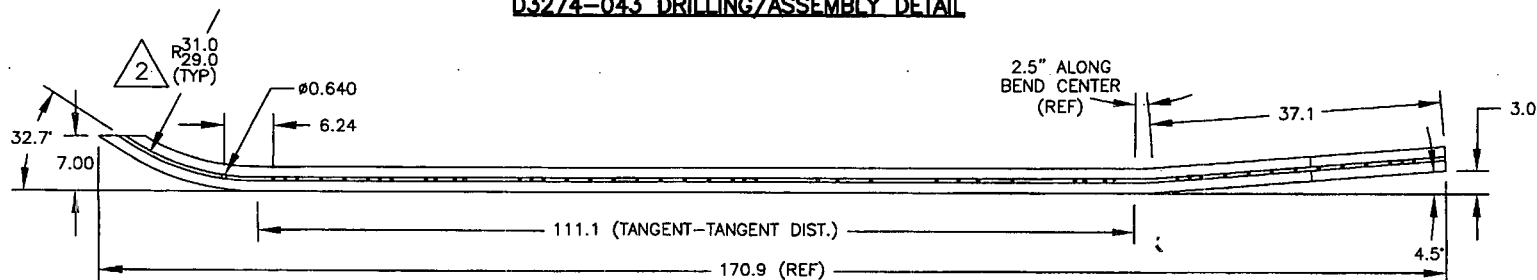
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

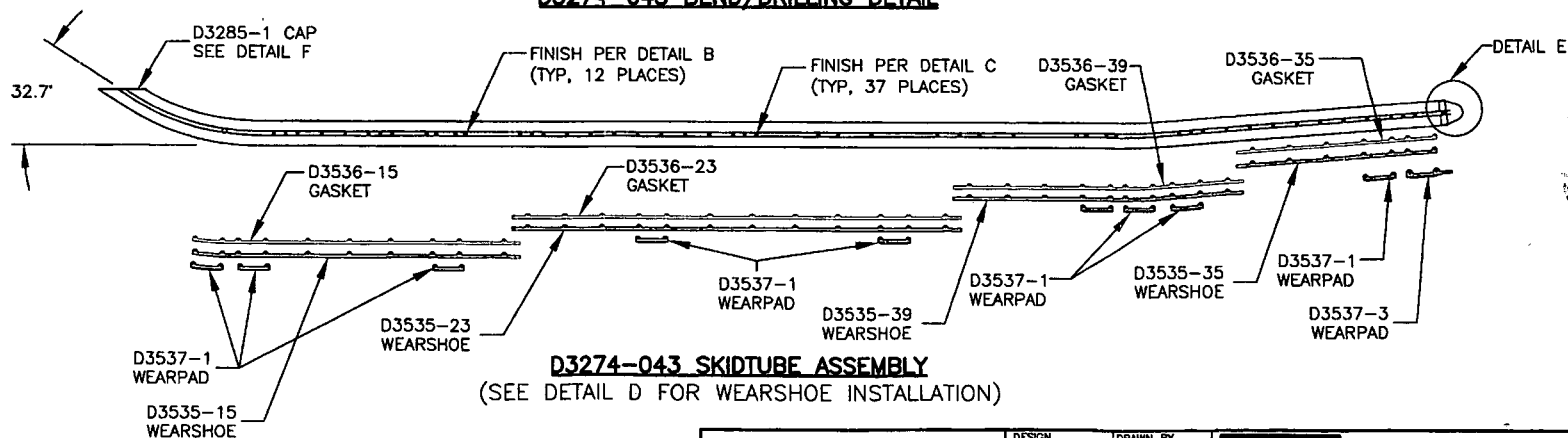
DEO ATTACHED



D3274-043 DRILLING/ASSEMBLY DETAIL



D3274-043 BEND/DRILLING DETAIL



D3274-043 SKIDTUBE ASSEMBLY
(SEE DETAIL D FOR WEARSHOE INSTALLATION)

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07.02.12

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DESIGN	CP	DRAWN BY	PH	DART DART AEROSPACE USA, INC. PORT HADLOCK, MA	REV. D
CHECKED	H	APPROVED	H	DRAWING NO. D3274	SHEET 3 OF 4
DATE	06.12.19	TITLE	SKIDTUBE ASSEMBLY	SCALE	1:15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

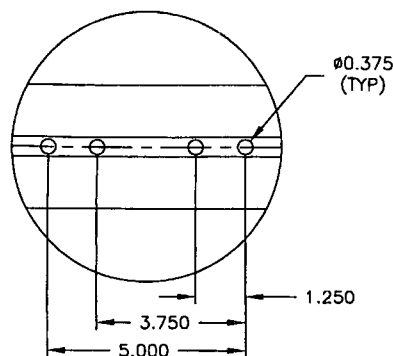
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NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

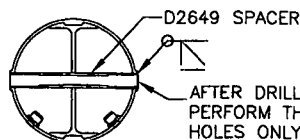
NOTE: Date & initial all entries

u/o 43372

DETAIL A: DRILL DETAIL

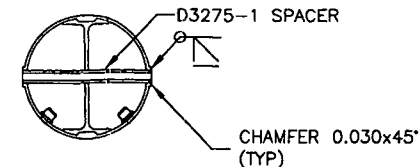


DETAIL B FOR 0.375 HOLES ONLY

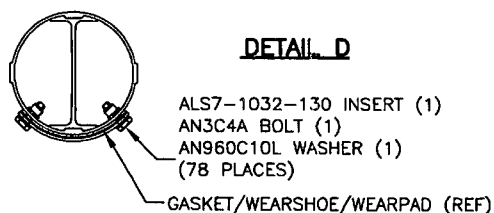


- AFTER DRILLING AND BENDING ASSEMBLY
PERFORM THE FOLLOWING FOR 0.375
HOLES ONLY:
1. CHAMFER HOLE 0.030x45°
 2. INSERT D2649 SPACER
 3. WELD INTO PLACE AND GRIND FLUSH
 4. C'BORE TO 0.313x0.75 DEEP

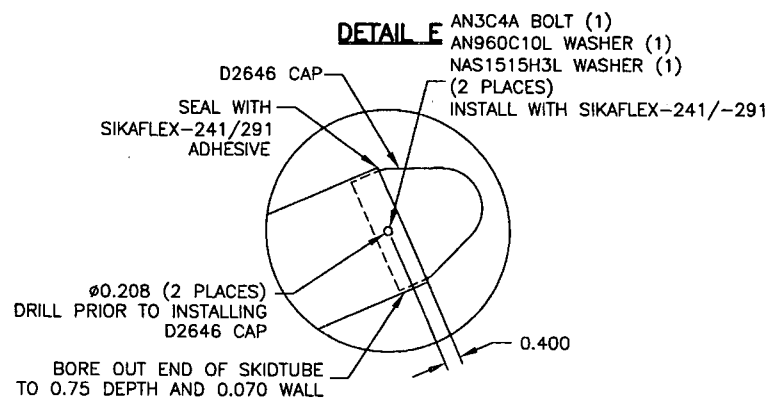
DETAIL C FOR 0.313 HOLES ONLY



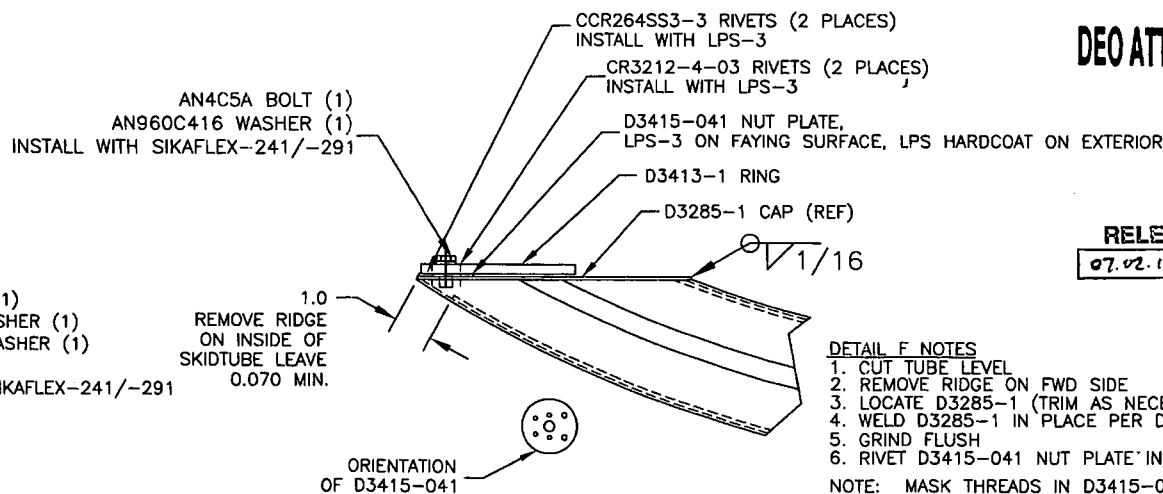
DETAIL D



DETAIL E



DETAIL F: END FINISHING DETAIL



- DETAIL F NOTES**
1. CUT TUBE LEVEL
 2. REMOVE RIDGE ON FWD SIDE
 3. LOCATE D3285-1 (TRIM AS NECESSARY)
 4. WELD D3285-1 IN PLACE PER DART QSI 004
 5. GRIND FLUSH
 6. RIVET D3415-041 NUT PLATE IN PLACE
- NOTE: MASK THREADS IN D3415-041
PRIOR TO FINISH

DEO ATTACHED

RELEASED
07.02.12

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--	--	---	------------------------------------	--	--

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DRAWING NO. D3274	TITLE SKIDTUBE ASSEMBLY	REV. D	DART AEROSPACE USA, INC ENGINEERING ORDER		D.E.O. NO. D3274-D-1	SHEET NO. SHEET 1 OF 1	SCALE NTS
DRAWN <i>UP</i>	CHECKED <i>[Signature]</i>	MFG. APPR. <i>[Signature]</i>	APPROVED <i>[Signature]</i>		DE APPR. <i>[Signature]</i>		
DATE 09.06.17	DATE 09.06.23	DATE 09/06/23	DATE 09/06/23		DATE 09.06.23		

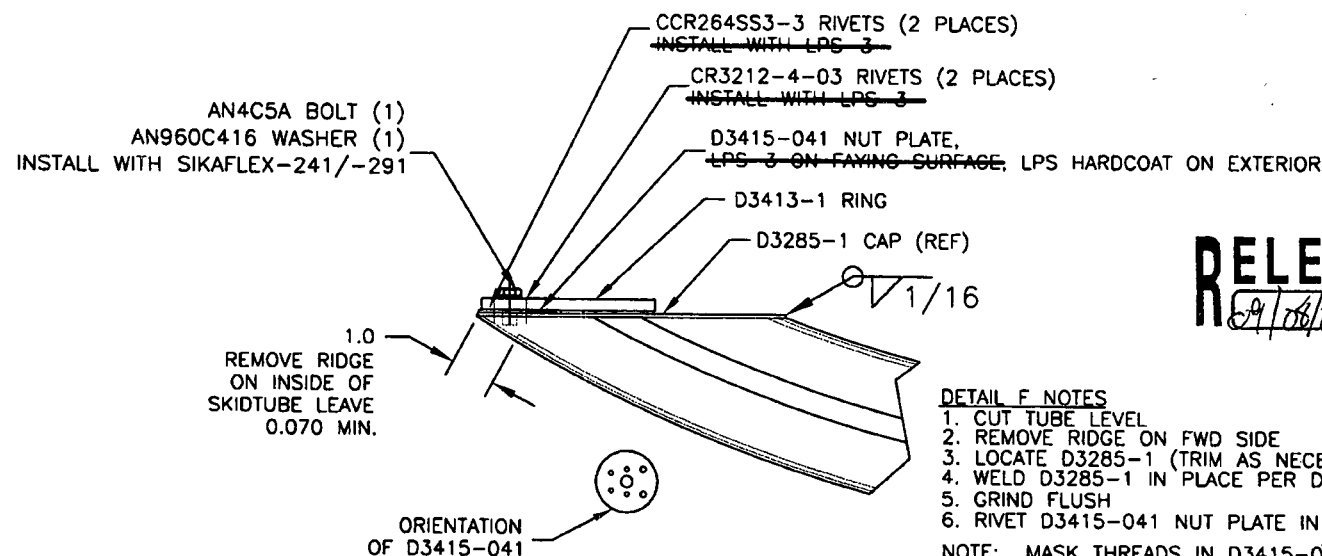
LPS-3 IS NO LONGER USED DURING ASSEMBLY OF SKIDTUBE.

AMEND NOTE 8: "~~SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES 'LPS 3' AFTER FINISH AND INSTALLATION OF INSERTS.~~
COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES 'LPS PROCYON' AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF
POWDER COATING WITH MEK DEGREASER."

AMEND DETAIL F AS SHOWN:

u/b 43372

DETAIL F: END FINISHING DETAIL



RELEASED
09/08/06

DETAIL F NOTES

1. CUT TUBE LEVEL
2. REMOVE RIDGE ON FWD SIDE
3. LOCATE D3285-1 (TRIM AS NECESSARY)
4. WELD D3285-1 IN PLACE PER DART QSI 004
5. GRIND FLUSH
6. RIVET D3415-041 NUT PLATE IN PLACE

NOTE: MASK THREADS IN D3415-041
PRIOR TO FINISH

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

NO. 241

AWS D17.1.2001
QUALIFICATION TEST RECORD

Name: Barclay Elliott
Job number: 62280
Part number: D206 642.541
Description: 206 skid
Welding Process: Tig ☒ Mig ☐
Base material: Aluminium
Current: AC ☒ DC ☐

TEST REQUIREMENTS AND RESULTS

Visual: pass ☒ fail ☐
Penetration: pass ☒ fail ☐

UNACCEPTABLE

Cracks: pass ☒ fail ☐
Undercut: pass ☒ fail ☐
Pin holes: pass ☒ fail ☐
Overlap (cold lap): pass ☒ fail ☐
Porosity (surface): pass ☒ fail ☐
Coloration: pass ☒ fail ☐

Qualifier P.D.D. Date of Test Coupon 10.09.30
Welder Barclay Elliott Date of Test Coupon 10.09.30

The above named individual is qualified in accordance with AWS D17.1.2001 to weld.